

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027805**Date Inspected:** 20-Jun-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** William Norris**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI was at Pier 7 to check the status of the East OBG corner assembly and noted that the parts welded during the previous shift have been marked by Quality Control as being visually and ultrasonically acceptable. The QAI noted that there was no Quality Control Inspector (QCI) present at this time, 8:15 am. The QAI confirmed that the time of welding completion was approximately 4 pm yesterday and noted that per the contract requirements, there is a 24 hour minimum waiting time for final ultrasonic testing. The QAI spoke with the QCI William Norris and it was confirmed that inspection was performed on the assembly modifications. The QAI noted later in this shift, the assembly has been loaded onto a barge and there is no longer safe access to the welded areas. The QAI wrote a non-conforming incident report, documenting that non-conforming inspections have been performed on the modified corner assembly. See the attached photo.

The QAI witnessed work in progress related to Contract Change Order (CCO) 179. The QAI noted that the shielded metal arc welding (SMAW) fillet welding is being performed by Jason Collins, ID 8128. At each access gate location, 2 retainer arms and 2 stoppers are being fit-up and welded. The QAI noted that the QCI Fred Michel is monitoring this work. The QAI was informed that the welding procedure specification (WPS) being used is ABF-WPS-D15-F1200A Rev.2. During this shift, the QAI made random observations of the work in progress. The QAI noted that the welding appeared to be within the requirements of the WPS and the work appeared to follow the CCO details. The QAI noted that access gates 23 and 26 have been installed and welded during this shift. See the attached photo.

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

The QAI assisted in conducting a thermal image survey of Skyway Bikepath Panels and identifying areas that need additional water removal / drain plugs installed. The QAI noted that this work is requested per Contract Change Order (CCO) # 217. The QAI relayed the observations to the Associate Steel Inspector (ASI) Jason Gramlick and the Structural Materials Representative (SMR) Nicolai Hvass. The QAI noted that the East half of the bikepath did not have any identifiable water.

The QAI reviewed contract documents at pier 7. The QAI used approved weekly welding report submittals and cross referenced the welding and inspection status as reported with QA records to identify the overall weld status. There were discussions with the Assistant Structural Materials Representative (ASMR) Parinaz Aghili, a list was reviewed and items to check were reviewed. The QAI began reviewing submittal 1106R120, R121 and R122 for conformance with the contract requirements. This work was in progress until the end of the shift.



Summary of Conversations:

The QAI relayed the status of the document reviews to the QAI Lead Bill Levell. The QAI attended the punch list meeting and there were discussions with the Assistant Structural Materials Representative (ASMR) Parinaz Aghili. A list was reviewed and items to check were reviewed. The QAI relayed the observations made last week. There were additional conversations regarding items that need additional information and when schedule allows, the QAI will continue checking punch list items. Except as described above, there were no other notable conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Croff, Scott	Quality Assurance Inspector
Reviewed By:	Levell, Bill	QA Reviewer
